

202 MINI SEAM

RECOMMENDED DOUBLE SEAM SPECIFICATIONS


SEAMING CHUCK ANGELUS 718L636 (or equiv.)
 FIRST OPERATION ROLL ANGELUS 297L641-R-90 (or equiv.)
 SECOND OPERATION ANGELUS 298L641-S-141 (or equiv.)

MACHINE SET UP SPECIFICATIONS (NOTE 1)		<u>US STANDARD</u>	<u>METRIC</u>
PIN HEIGHT (IN)	X 307	3.125 ± .003	79,38 ± 0,08
	X 413	4.500 ± .003	114,3 ± 0,08
	X 603	5.880 ± .003	149,35 ± 0,08
BASE PLATE LOAD (LBS)	(COLD FILL)	100 lbs ± 5 lbs	45.36 ± 2.27
	(HOT FILL)	130 lbs ± 20 lbs	58.97 ± 9.07

PRODUCT SPECIFICATIONS DIMENSIONS AND PARAMETERS	SET UP SPECIFICATION		OPERATING SPECIFICATION	
	(IN)	(METRIC)	(IN)	(METRIC)
FIRST OPERATION SEAM THICKNESS	0.076 ± 0.002	1,930 ± 0,051		
FIRST OPERATION COUNTERSINK DEPTH	0.270 ± 0.003	6,858 ± 0,076		
SECOND OPERATION SEAM THICKNESS	0.044 ± 0.001	1,118 ± 0,025	0.042 - 0.046	1,067 – 1,158
SECOND OPERATION COUNTERSINK DEPTH	0.270 ± 0.003	6,858 ± 0,076	0.270 ± 0.005	6,858 ± 0,127
SEAM HEIGHT	0.096 - 0.100	2,438 – 2,540	0.095 - 0.101	2,413 – 2,565
BODY HOOK LENGTH	0.065 ± 0.005	1,651 ± 0,127	0.055 - 0.075	1,397 – 1,905
COVER HOOK LENGTH	0.060 ± 0.005	1,524 ± 0,127	0.053 minimum	1,346 minimum
TIGHTNESS RATING	100%		90% minimum	
ACTUAL OVERLAP	0.035 minimum	0,889 minimum	0.025 minimum	0,635 minimum


NOTE 1: Machine set up specifications are for initial setting only. Adjustments from these settings should be made as needed to achieve product specification requirements

NOTE 2 Double seam quality is the responsibility of the customer.

Date: 08/17/98	Approved: RMR	Product: 202 END (.0086" & .0088")		Metal Beverage Container Operations 9300 W. 108th Circle, Westminster, CO 80021-3682 P.O. Box 589 Broomfield, Co 80038-0589	
Drawn: D. Stevens	Approved: TN			DOUBLE SEAM ALUMINUM CAN US STANDARD & METRIC 202/211 X 307 202/211 X 413 202/211 X 603	THE DESIGNS, INFORMATION AND DATA CONTAINED HEREIN ARE PROPRIETARY AND ARE SUBMITTED IN CONFIDENCE, AND SHALL NOT BE DISCLOSED, USED OR DUPLICATED IN WHOLE OR IN PART, FOR ANY PURPOSES WHATSOEVER WITHOUT THE PRIOR WRITTEN PERMISSION OF BALL CORPORATION. RECEIPT OF THIS DOCUMENT SHALL BE DEEMED TO BE AN ACCEPTANCE OF THE CONDITIONS SPECIFIED HEREIN.
Checked: DDS	Approved:	PRODUCT STANDARD	REV.		
Approved: RAM	Approved:	SEAM-201	C		

LIST OF REVISIONS

LET	DATE	DESCRIPTION	APPROVED
A	8/9/99	WAS: 90 LBS ± 5 LBS (BASE PLATE LOAD, 12 & 16 OZ) NOW: 100 LBS ± 5 LBS (BASE PLATE LOAD, COLD FILL) WAS: 200 LBS ± 20 LBS (BASE PLATE LOAD HOT FILL) NOW: 130 LBS ± 20 LBS WAS: 0.078 ± 0.002 (FIRST OPERATION SEAM THICKNESS) NOW: 0.076 ± 0.002 WAS: 0.0108 ALUMINUM CAN (TITLE BLOCK) NOW: ALUMINUM CAN, 202/211 X 413, 202/211 X 603 ADDED : 0.0088" (TITLE BLOCK)	DDS/RM/TN
B	4/12/01	ADDED METRIC EQUIVALENTS TO SPECIFICATION	NZ/RM/TN
C	1/18/02	ADDED 202/211 X 307 INFORMATION	NZ/RM/JB

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